

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009619**Date Inspected:** 17-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Panels**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

Pursuant to NDT Inspection Notification (Document Number 003982), QA Inspector attempted to perform Initial VT as a three party inspection on DP346-001, welds 001 thru 008. Upon arrival, this QA Inspector found that no Certified Welding Inspectors were present for either ZPMC or ABF. This QA Inspector informed ZPMC that welding activities were only to be performed in the presence of a CWI, at which time ZPMC QC notified the ZPMC CWI. Upon the arrival of the ZPMC CWI who was visibly angry, this QA Inspector was threatened with physical violence and death and assaulted with verbal abuse and vulgar language. This QA Inspector did then speak to the ZPMC CWI's supervisor, however ZPMC withdrew thier request for initial VT of the above-mentioned Deck Panel.

QA Inspector performed layout of transverse UT indications found in the OBE1 (1AE to 1BE) transverse splice weld. Layout of weld indications occurred in weld OBE1A-009 and OBE1A-008. Y-locations of 20 transverse UT Indications found in noncompliance with the minimum requirements of AWS D1.5;2002 Table 6.3. This QA Inspector made a report of findings to Mike Foerder for tracking purposes and incorporation in the punchlist.

QA Inspector worked on Document Control for U-rib deck panels. Deck panel PAUT reports input and updated for lift 10 and 11 deck panels. Deck panel PAUT reports organized and copied for transmittal and summary update. Deck panel log for lifts 10 and 11 deck panel assemblies updated and the Complete deck panel log updated.

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QA Inspector continued organizing Deck Panel reports for archive. SMR deck panel summary spreadsheet reviewed and corrected. SMR Deck Panel Tack Weld Assessment Summary updated.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan
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Quality Assurance Inspector

Reviewed By:	Hall,Steven
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QA Reviewer
